

Date: Thursday, 3/8/2007 12:36:50 PM
User: Kim Johnston

Process Sheet

SPILT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUAL MIRROR ASSEMBLY
Job Number	: 31102 2		
Estimate Number	: 12278		
P.O. Number	: N/A	Part Number	: D206558043
This Issue	: 3/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D206-558 PG4-6/D2066
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28814	Drawing Revision	: C / B
		Material	: N/A
Written By	: <u>07.03.08</u>	Due Date	: 3/30/2007
Checked & Approved By	: <u>07.03.08</u>	Qty:	2 Um: Each
Comment	: Est. G 02 09 19 Re-format; Incorporated D2066 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-558-043 CHG005

2.0	D2011101	Mirror 6"
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mirror 6"

Pick:

Qty Part Number Description Batch

2 D2011-101 Mirror Ass'y 6"

B 29773

FF 07-03-21

5

3.0	D2052	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bracket

Batch B 17216

FF 07-03-14

5

4.0	D2054	Bushing - Delrin
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing - Delrin

Batch B 16711

FF 07-03-14

5

5.0	D2055	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clamp

Batch B 16712

FF 07-03-14

5

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2056

Bell Crank Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bell Crank Assembly

Batch B26514

FF 07-03-14

5

7.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 AN960JD10 Washer M103585

FF 07-03-21

5

8.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

* 2 MS21042L3 Nut M102650
or MS21042-3

FF 07-03-21

5

9.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty Part Number Description Batch

2 MS27039-1-18 Screw M12307

FF 07-03-21

5

10.0

M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.: 2.8000 f(s)/Unit Total : 14.0002 f(s)

304 RD Tube .500 x .035W

304/316 SS Seamless Tube

(Ref. QSI 017 4.1.1.2) as per Dwg D2066 using punch Jig DT8012.

Identify as D2066.

Batch: M103453

Deburr and Polish

Note: Punch 1 end only at this time.

FF 07-03-14

5

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Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch 1/2" OD x .035" Wall

Slide on parts D2052, D2055, D2056, D2054 as per Dwg D206-558

Note orientation of belcrank and order of parts.

Punch other end to length (28.62") as per Dwg D2066

Use template DT8054

FF 07-03-15 5

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Flatten the ends on Hydraulic press using DT8545

Bend per Dwg D2066 using template D2066T1

Deburr

Drill 3/16" Dia holes per D2066T1 template and Dwg D2066

Deburr holes

Assemble remaining parts as per Dwg D206-558

FF 07-03-21 5

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/21 (5)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

15.0

D2053

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number Description Batch

1 D2053 Bracket

516710 ✓

16.0

D2067

Connector



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Connector

Pick: Packing Kit

~~D2067-15~~ 07/03/23 (5)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch
1 D2067 Connector

B20875 ✓

17.0

D2071

Cable Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty Part Number Description Batch
1 D2071 Cable

B26525 (30) ✓

B31222

18.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch
4 AN3-4A Bolt

M103641 ✓

19.0

AN5261032R9

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Screw

Pick: Packing Kit

Qty Part Number Description Batch
4 AN526-1032R9 Screw

M101189 ✓

or AN526C1032R9

20.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch
4 AN960JD10L Washer

M101291 ✓

21.0

MS21919DG5

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp
or MS21919WDG5

M17864 ✓

2/24/03/23 (5)

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Description:

22.0

MS354899

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-9 Grommet

119619 ✓

7/3/23 (5) ✓

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/3/29 (5)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: D

7/4/20

7/4/20

59 (2)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/10/24

Job Completion



U 8/24/24